

Work Order ID 75148

October-18-11 8:12:34 AM

75148

Page 1

Item ID: D3230-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Wedge Assembly

Start Date: 10/18/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/28/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3230

Rev C

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
2- Drill and c/sink holes
3- cut mesh as per dwg
4 -Deburr & Remove all Markings From Material
5-Weld bushings and fabricate basket wedge assembly as per D3230
A/R SS ROD Batch: 114649

PLU. 10.18

1X

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

11.10.18

Work Order ID 75148

October-18-11 8:12:34 AM

75148

Page 2

Item ID: D3230-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Wedge Assembly

Start Date: 10/18/11

Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/28/11

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

**** if necessary****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

M117745

12:00
400 OF
12:30

1X/M-L 11/10/20

Work Order ID 75148

October-18-11 8:12:34 AM

75148

Page 3

Item ID: D3230-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Wedge Assembly

Start Date: 10/18/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/28/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 BR 11-10-20.

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

PPP ?

11/11/25

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/10/27
MF
11-10-26

Picklist Print

October-18-11 8:12:33 AM

Page 1

Work Order ID: 75148

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 10/18/11

Required Date: 10/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D2232-3 Basket Hinge		Manufactured	No			110	Each	5.0000	2	2		Pl 11.10.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		5							
				72929		5			2	2			
✓ D2327-3 Spacer Bushing		Manufactured	No			110	Each	18.0000	2	2		Pl 11.10.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		18							
				71971		1							
				72963		17			2				
✓ D3759-1 Bushing		Manufactured	No			110	Each	87.0000	5	5		Pl 11.10.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		85							
				72316		85			5				
				WA005		2							
				66489		2							
✓ M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			110	sf	779.7855	5.15	5.4210526		Pl 11.10.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		779.78548							
				117197		102.9036							
				117896		53.3264							
				118153		82.2683				5.4210			
				118248		33.0983							
				118597		73.01888							
				118955		115.17							
				119180		320							

Picklist Print

October-18-11 8:12:33 AM

Page 2

Work Order ID: 75148

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 10/18/11

Required Date: 10/28/11

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

110 f

686.1922

25.2966

26.628

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT018

664.5280585

117636

67.9987

118773

596.529359

WA

6.0667

118181

6.0667

WA007

15.5974906

116267

14.628472

116763

0.9690186

Pl 11.10.18

26.628

October-18-11 8:12:33 AM

Shop Packet Print

Page 2

25148

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING

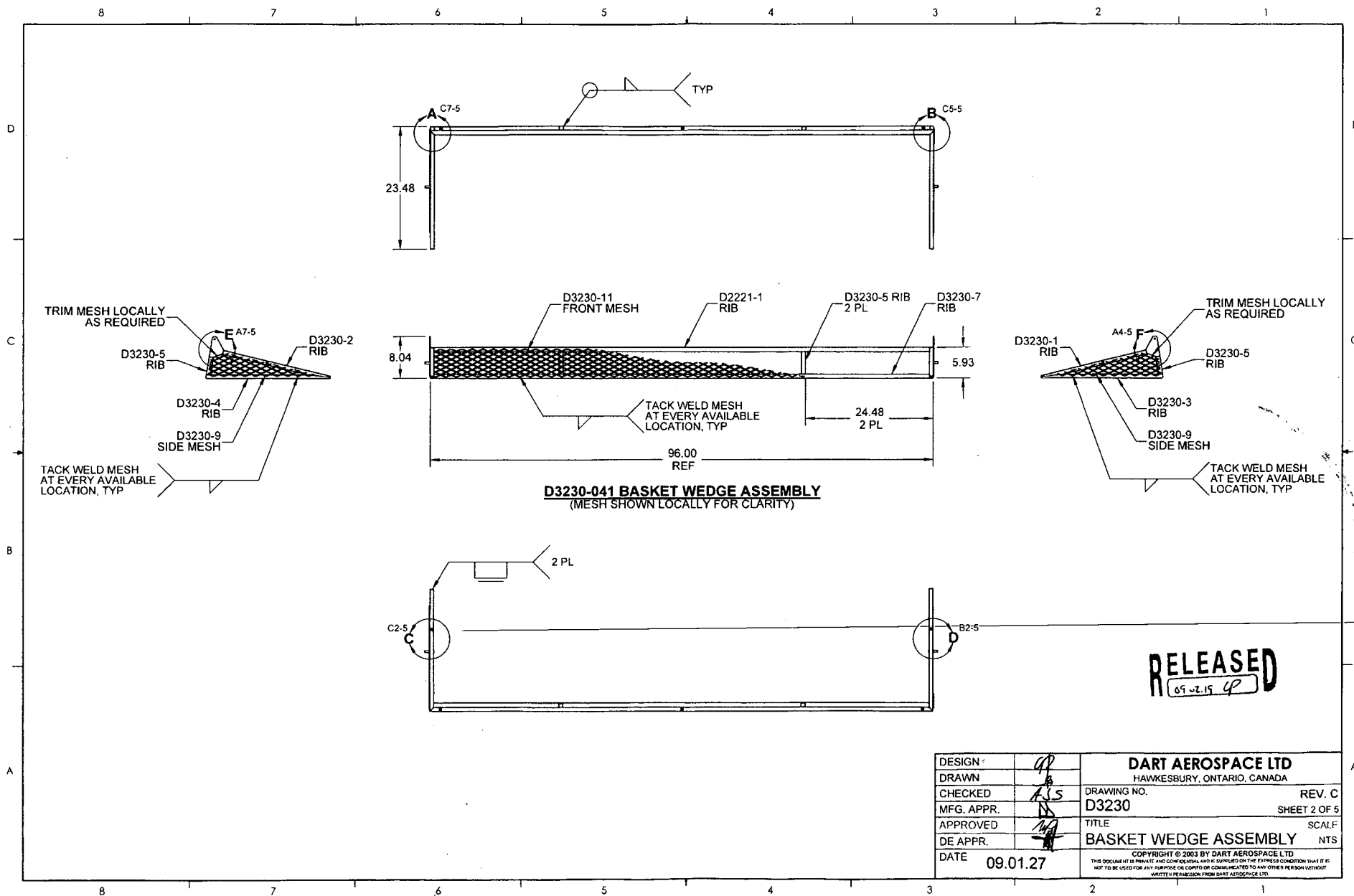
D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
09.02.19 CP
PER ECN 05-534

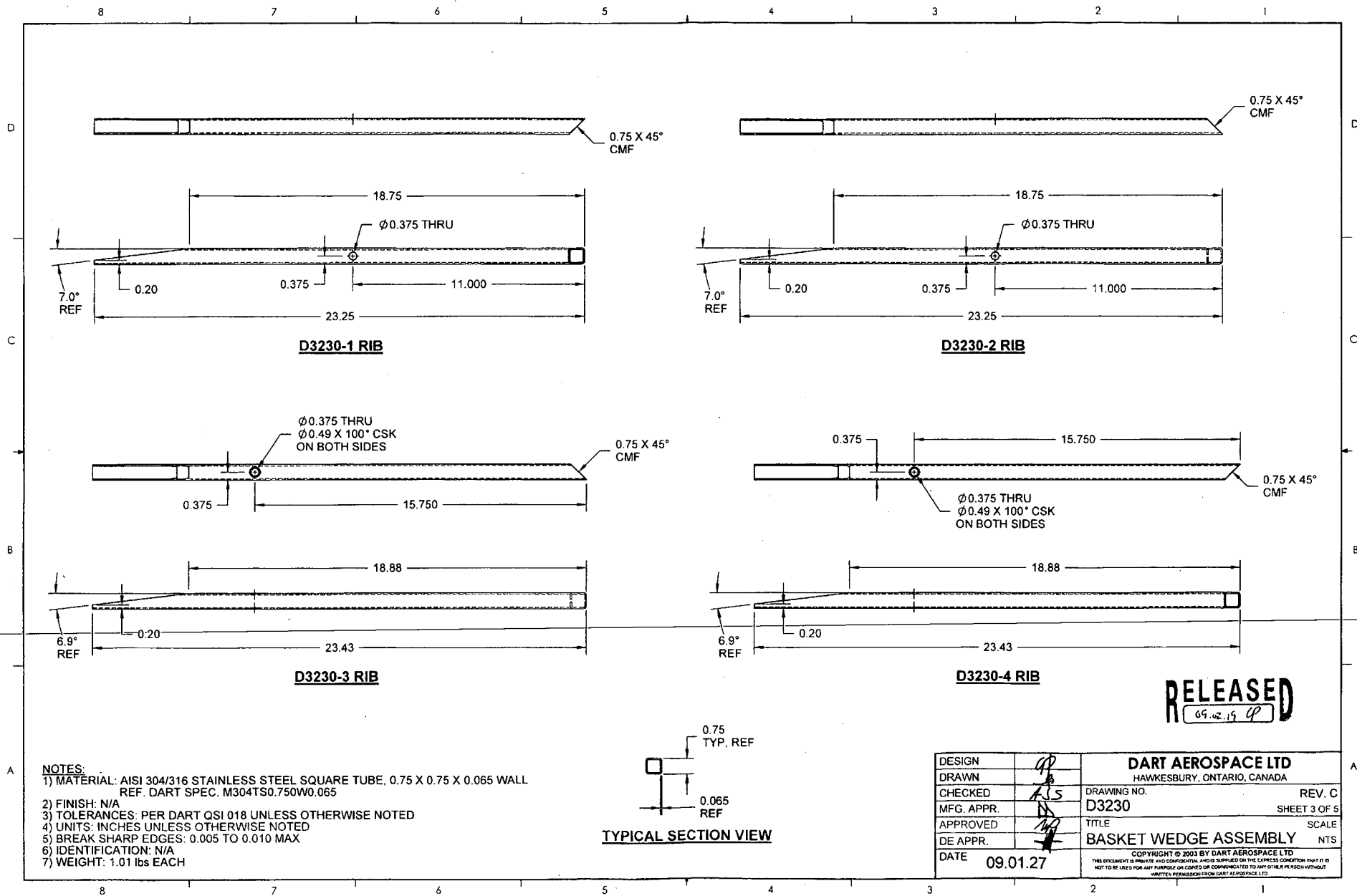
C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 1 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004



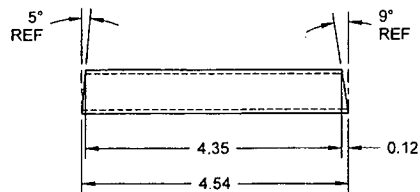
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09-02-15



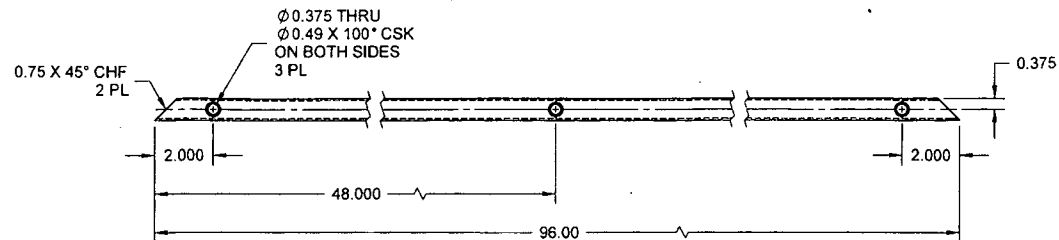
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.01 lbs EACH

RELEASED
09.02.19 4P

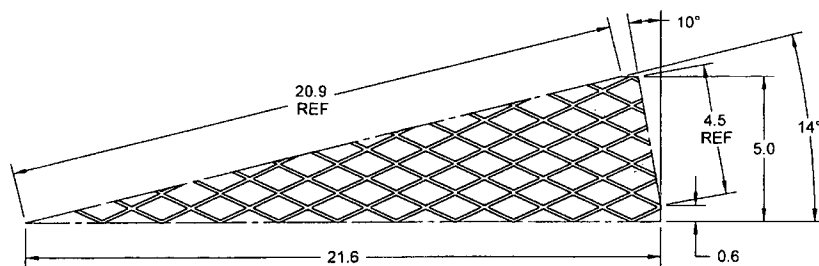
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D3230	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET WEDGE ASSEMBLY	NTS
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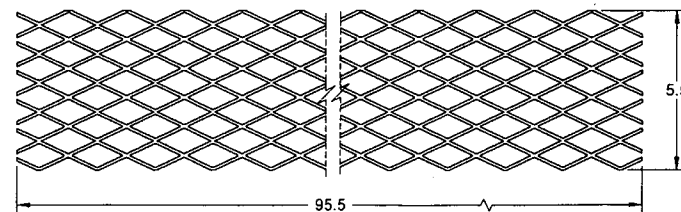
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

NOTES:

1) MATERIAL:

D3230-5/-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

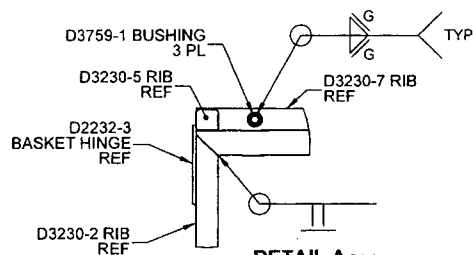
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

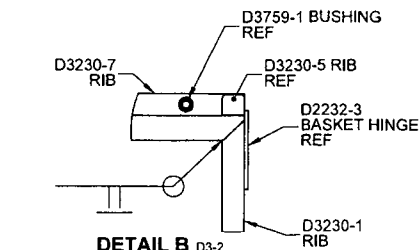
**7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs**

RELEASED
09.01.27

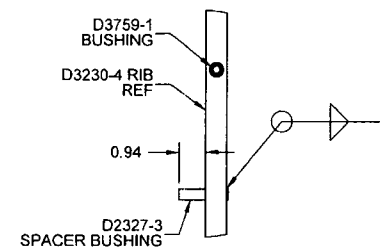
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3230	REV. C
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE BASKET WEDGE ASSEMBLY	SCALE
DE APPR.			NTS
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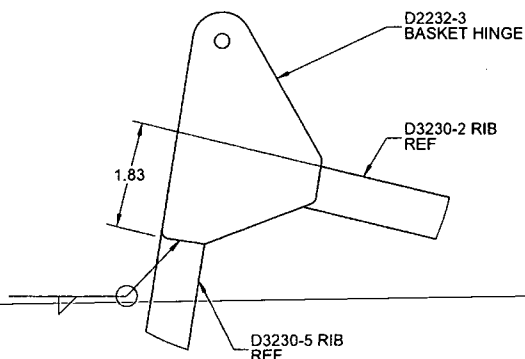
DETAIL A D6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



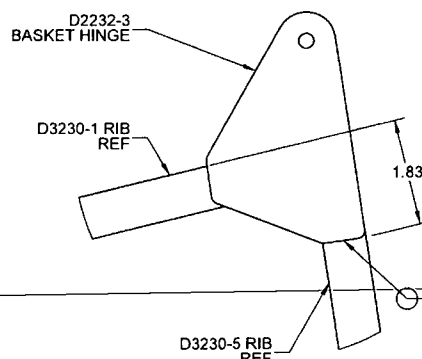
DETAIL B D3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



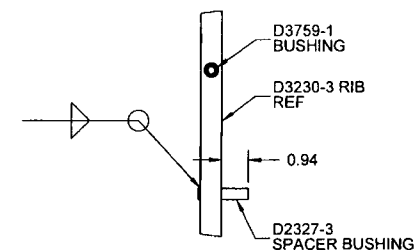
DETAIL C B6-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X



DETAIL E C7-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL F C2-2
MESH NOT SHOWN FOR CLARITY
SCALE 8X



DETAIL D B3-2
MESH NOT SHOWN FOR CLARITY
SCALE 4X

RELEASED
09-21-94

DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JP			
CHECKED	ALS		DRAWING NO.	REV. C
MFG. APPR.	DP		D3230	SHEET 5 OF 5
APPROVED	DP		TITLE	SCALE
DE APPR.	DP		BASKET WEDGE ASSEMBLY	NTS
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